

Work Order ID 131997

Tuesday, April 21, 2015 1:59:40 PM

131997

Page 1

Item ID: D4079-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp Half, Attachment
Start Date: 4/17/15 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 15-04-23 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4079	B

100

0.00

100

Bandsaw

Memo 71
Cut blank 2.750" long

0.00

Jeaspa Bandsaw

13
15-05-10

110

0.00

110

HAAS 1

Memo
Mill as per Dwg and Folio FA931
Folio rev: B
Dwg Rev: B

0.00

HAAS CNC vertical machine #1

13
15-05-11

Deburr

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 131997

Tuesday, April 21, 2015 1:59:40 PM

131997

Page 4

Item ID: D4079-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Clamp Half, Attachment

Stop ***NS2***

Start Date: 4/17/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

15/6/2 28

Dis. 6.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Tuesday, April 21, 2015 1:59:40 PM

Page 1

Work Order ID: 131997

131997

Parent Item: D4079-1

D4079-1

Parent Item Name: Clamp Half, Attachment

Start Date: 4/17/15

Required Date: 4/20/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	27.0000	0.23	2.905264			

M6061T6B2 000X02 000

**

6061-T6 Bar 2.00 x 2.00

Location

MAT004

m129375

Loc Qty

27

27

Loc Code

15-15-10

30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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		OTHER :							

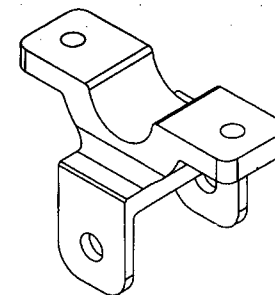
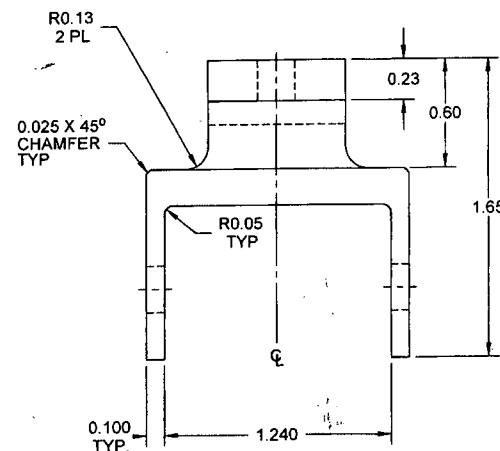
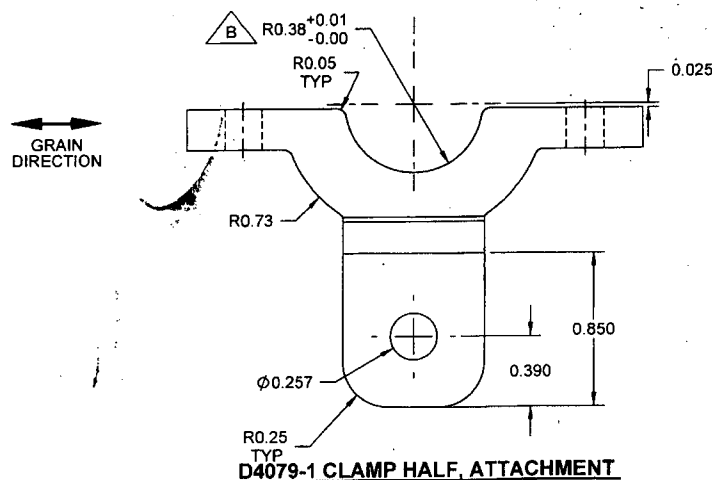
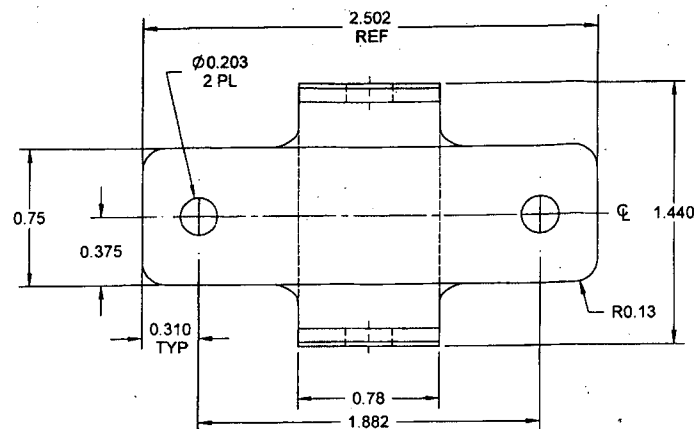
DART AEROSPACE LTD		Work Order: 131997
Description: Clamp Half, Attachment		Part Number: D4079-1
Inspection Dwg: D4079	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.502	+/-0.010	2.501	✓		Vern HP 09	
Ø0.203	+0.005/-0.001	.203	✓			
0.75	+/-0.030	.750	✓			
0.375	+/-0.010	.375	✓			
0.310	+/-0.010	.309	✓			
1.882	+/-0.010	1.882				
0.78	+/-0.030	.778	✓			
R0.13	+/-0.030	.125	✓			
1.440	+/-0.010	1.440	✓			
R0.38	+0.010/-0.000	.385	✓			
R0.050	+/-0.010	.05	✓			
R0.73	+/-0.030	.730	✓			
Ø0.257	+0.006/-0.001	.257	✓			
R0.25	+/-0.030	.250	✓			
0.390	+/-0.010	.389	✓			
0.850	+/-0.010	.851	✓			
0.025 x 45°	+/-0.010 x 0.5°	.025	✓			
0.100	+/-0.010	.100	✓			
R0.05	+/-0.030	.052	✓			
1.240	+/-0.010	1.240	✓			
1.65	+/-0.030	1.653	✓			
0.60	+/-0.030	.601	✓			
0.23	+/-0.030	.224	✓			
0.025	+/-0.010	.025	✓			

Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 15-05-10	Date: 15-5-11	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	[Signature]



UNCL
S

NO 131997 MJS
1504-23

RELEASED
2010-09-07
JMP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4079-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

B	R0.38 WAS R0.48.	JB	10.07.30
A	NEW ISSUE	JB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN	JB		
CHECKED	JB		
MFG. APPR.	JB		
APPROVED	JB		
DE APPR.	JB		
DATE	10.07.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4079	REV. B SHEET 1 OF 1
TITLE CLAMP HALF, ATTACHMENT	SCALE NTS
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